

Date: Tuesday, 8/21/2007 3:43:53 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER REVIEW
Job Number : 34194	
Estimate Number : 12927	
P.O. Number : <i>N/A</i>	Part Number : D29391UP
This Issue : 8/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2939 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/20/2007 Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A New Issue 07-07-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Issue material from stock: 7075-T7351 QQ-A-250/12
Cut Size 2.0 x 6.25 X 6.00
Grain Along Long 6.00 Length
Batch No: *31386*

BE 02.09.12

(10)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program part number and batch number.
1-Inspect part number and batch number are programmed correctly.
2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet
5-Deburr

S.F 07/09/13 (10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

S.F 07/09/14 (10)

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

S.F 07/09/14 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/13	2.0.	The 3 rd operation 1X origin was off by .020". R.C. operator error	MS 07/09/13	Scrap, destroy, replace. retake origin.	SB 07/09/13	Er 07/09/13	MS 07/09/13	Er 07/09/13

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE - UNDER
REVIEW

Job Number: 34194

Part Number: D29391UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/09/14

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ml 07 09 17

(10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

~~11/15/17~~

07/09/18 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/09/18 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/19

Job Completion



u 07-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 34194
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.126	.127	.127		
B	0.100	0.140		.125	.126	.127	.127		
C	0.100	0.140		.125	.125	.125	.130		
D	0.210	0.230		.225	.225	.225	.220		
E	1.245	1.255		1.250	1.251	1.251	1.251		
F	1.245	1.255		1.250	1.247	1.247	1.247		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.506		
I	1.572	1.582		1.576	1.580	1.580	1.580		
J	2.495	2.505		2.501	2.500	2.500	2.500		
K	0.257	0.262		.260	.257	.257	.258		
L	0.312	0.317		.3125	.314	.314	.315		
M	0.235	0.240		.238	.238	.238	.239		
N	0.100	0.140		.127	.125	.125	.124		
O	0.540	0.560		.550	.550	.552	.550		
P	0.490	0.510		.500	.502	.510	.510		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.747	2.747	2.747	2.747		
S	0.240	0.270		.250	.250	.255	.255		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.631	1.631	1.631	1.631		
V	1.362	1.372		1.369	1.369	1.370	1.369		
W	0.316	0.321		.318	.318	.318	.318		
X	1.250	1.270		1.262	1.262	1.258	1.258		
Y	1.565	1.585	DT8695 A/B	1.580	1.580	1.578	1.578		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.S.
Date: 07/09/13

Audited by: J.F.
Date: 07/09/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	34194
Description: 206 Saddle, Inboard, Left side	Part Number:	D2939-1
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		.125	.125	.126	.125		
B	0.100	0.140		.125	.125	.126	.125		
C	0.100	0.140		.125	.129	.129	.129		
D	0.210	0.230		.225	.225	.226	.226		
E	1.245	1.255		1.250	1.255	1.255	1.255		
F	1.245	1.255		1.250	1.250	1.255	1.255		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.580	1.575		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.240	.240	.240	.240		
N	0.100	0.140		.125	.125	.127	.127		
O	0.540	0.560		.550	.550	.556	.550		
P	0.490	0.510		.500	.509	.509	.509		
Q	3.715	3.725		3.720	3.720	3.720	3.717		
R	2.720	2.760		2.750	2.750	2.747	2.745		
S	0.240	0.270		.256	.256	.258	.257		
T	0.100	0.180		.123	.130	.130	.145		
U	1.625	1.635		1.631	1.631	1.621	1.631		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.320	.320	.320	.319		
X	1.250	1.270		1.252	1.252	1.259	1.259		
Y	1.565	1.585	DT8695 A/B	1.580	1.580	1.581	1.581		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F.
Date:	07/09/13

Audited by:	J.F.
Date:	07/09/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 34194
Description: 206 Saddle, Inboard, Left side	Part Number: D2939-1
Inspection Dwg: D2939 Rev. C	Page 1 of 1

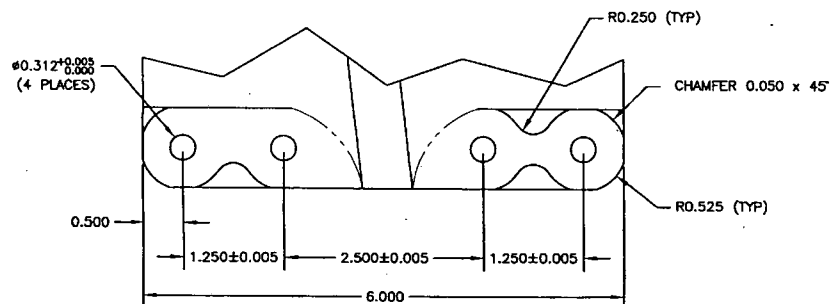
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	91	101	3	4		
A	0.100	0.140		.127	.127				
B	0.100	0.140		.125	.125				
C	0.100	0.140		.125	.125				
D	0.210	0.230		.223	.225				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.501				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.574	1.577				
J	2.495	2.505		2.501	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.240	.240				
N	0.100	0.140		.125	.127				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.510	.510				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.747	2.747				
S	0.240	0.270		.250	.250				
T	0.100	0.180		.144	.144				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.368				
W	0.316	0.321		.320	.320				
X	1.250	1.270		1.258	1.258				
Y	1.565	1.585	DT8695 A/B	1.567	1.567				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.P.
Date: 07/09/14

Audited by: J.F.
Date: 07/09/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

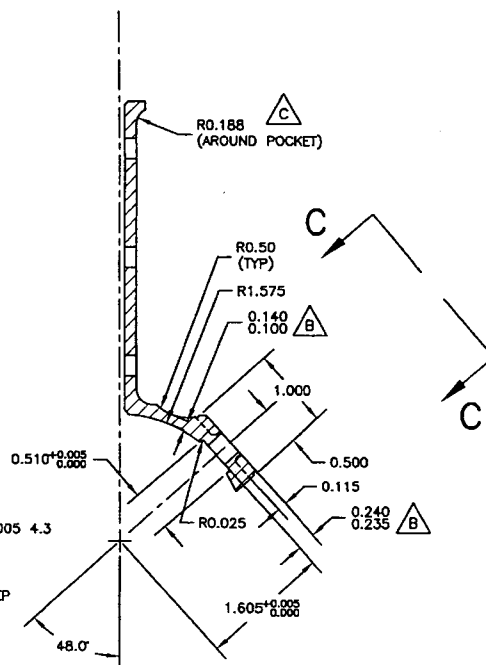


VIEW C-C

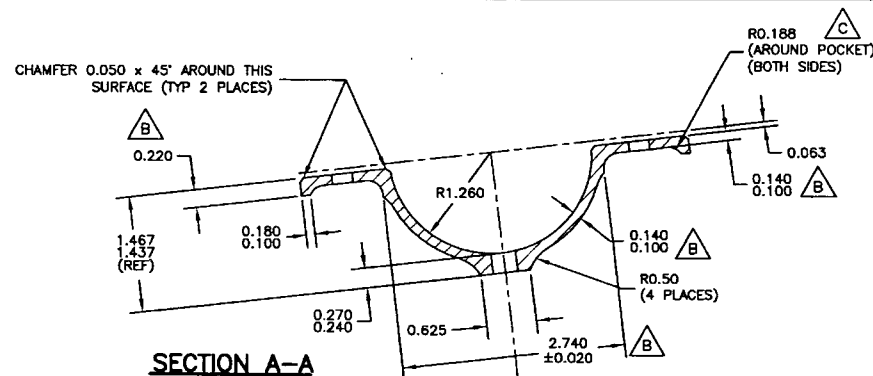
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:

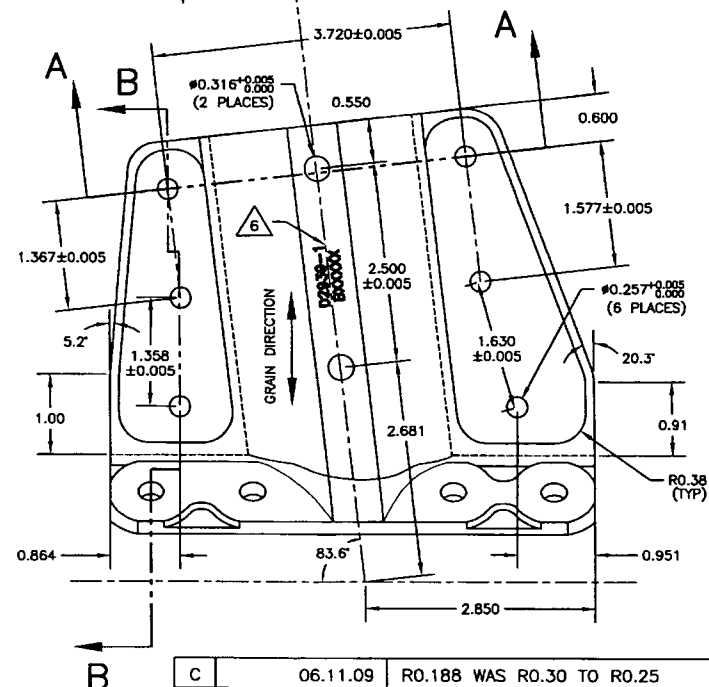
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2939
DATE	06.11.09	TITLE SADDLE INSIDE

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REV. C

SHEET 1 OF 1

SCALE

2:3

NO. 34184
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07.02.12